

Date:  
User:Thursday, 11/23/2006 11:55:28 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206
Job Number	: 29668		
Estimate Number	: 10820		
P.O. Number	: <i>N/A</i>	Part Number	: D26661
This Issue	: 11/23/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2666 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 28603	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/5/2006 Qty: 12 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: *B 25343**9ml 06/12/19*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly. ✓

2-Fixturing Inspection last completed on *06.12.16* by *SD*

3-Machine Step No.1 of Folio and visually inspect as per attached Dimension Sheet ✓

6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

9- Deburr

*SD/J.L./9ml 06/12/19*PTO  
(12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*J.L./9ml 06/12/19*

(12)

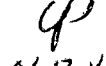
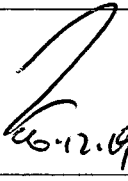
4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE






Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SD/J.L./9ml 06/12/19*

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.12.14	2	Tool rad of flange pocket should be R0.188. Saddle-to-cross-tube holes should be $\phi 0.316$ , as marked-up on dsg.  REF: Attached DS email		gml	06/12/14	12	 06.12.14 PC QSI 042	 06.12.14

Part No: D2666-1 PAR #: 44A Fault Category: Prod/Machine Parts NCR: Yes No DQA: 27 Date: 06/12/22  
QA: N/C Closed: 78 Date: 06.12.22

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date		
06/12/17	2	wrong tool offset, Tool drove into saddle at the skid hole location. Operator error.	 QSI 042	scraps and replace		gml 06/12/19	 06.12.19	 06.12.19

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:55:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 29668

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EP 06/12/20 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JP/a.m

06/12/20

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 102391

M.E/a.m

06/12/22

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PV 06/12/22 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51483

EP 06/12/22 (12)

PP 06/12/22 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22 (12)

Job Completion



C 06/12/22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29668
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 /	2 /	3 /	4 /		
A	0.100	0.140		.123	.123	.123	.122		
B	0.100	0.140		.120	.120	.120	.119		
C	2.470	2.510		2.501	2.501	2.500	2.500		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.219	.221	.219	.220		
F	1.313	1.343		1.323	1.325	1.323	1.328		
G	0.240	0.260		.249	.249	.249	.250		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.133	1.134	1.133	1.132		
J	0.990	1.010		1.004	1.000	1.000	.999		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.512	.512	.512	.512		
M	0.100	0.120		.120	.120	.120	.112		
N	1.565	1.585		1.580	1.581	1.582	1.580		
O	5.990	6.010		6.000	6.002	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.499	.501		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.497	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.361	1.362		
V	0.315	0.321		.319	.318	.318	.318		
W	0.540	0.560		.549	.550	.549	.550		
X	1.674	1.684		1.679	1.679	1.678	1.678		
Y	0.257	0.262		.259	.255	.259	.259		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SN / 3.2
Date: 06.12.17

Audited by: [Signature]
Date: 06.12.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	29668
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	0.126	0.116		
B	0.100	0.140		.119	.119	0.113	0.113		
C	2.470	2.510		2.501	2.501	2.501	2.501		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.220	.219	0.216	0.212		
F	1.313	1.343		1.325	1.324	1.318	1.320		
G	0.240	0.260		.248	.249	0.251	0.242		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.133	1.134	1.128	1.135		
J	0.990	1.010		1.000	1.001	1.002	1.003		
K	0.235	0.240		.238	.238	0.236	0.236		
L	0.510	0.515		.512	.512	0.512	0.512		
M	0.100	0.120		.113	.116	0.115	0.110		
N	1.565	1.585		1.580	1.579	1.580	1.580		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.499	.500	0.502	0.502		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.361	1.361		
V	0.315	0.324		.318	.318	0.318	0.318		
W	0.540	0.560		.550	.550	0.550	0.550		
X	1.674	1.684		1.679	1.678	1.678	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.L. 19ml
Date:	06/12/18 / 06/12/19

Audited by:	CA
Date:	06/12/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29668
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>




Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.121	0.119	0.121	0.121		
B	0.100	0.140		0.114	0.115	0.113	0.116		
C	2.470	2.510		2.500	2.499	2.495	2.499		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.213	0.213	0.212	0.214		
F	1.313	1.343		1.322	1.322	1.319	1.320		
G	0.240	0.260		0.245	0.243	0.245	0.243		
H	0.615	0.685		0.655	0.655	0.655	0.655		
I	1.125	1.145		1.140	1.138	1.138	1.144		
J	0.990	1.010		1.001	1.001	1.003	1.002		
K	0.235	0.240		0.236	0.236	0.236	0.236		
L	0.510	0.515		0.512	0.512	0.512	0.512		
M	0.100	0.120		0.110	0.110	0.110	0.110		
N	1.565	1.585		1.580	1.582	1.580	1.575		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.502	0.503	0.502	0.502		
S	0.313	0.318		0.314	0.314	0.314	0.314		
T	2.495	2.505		2.499	2.499	2.500	2.500		
U	1.357	1.367		1.361	1.361	1.361	1.361		
V	0.315	0.328		0.320	0.320	0.320	0.320		
W	0.540	0.560		0.548	0.550	0.548	0.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

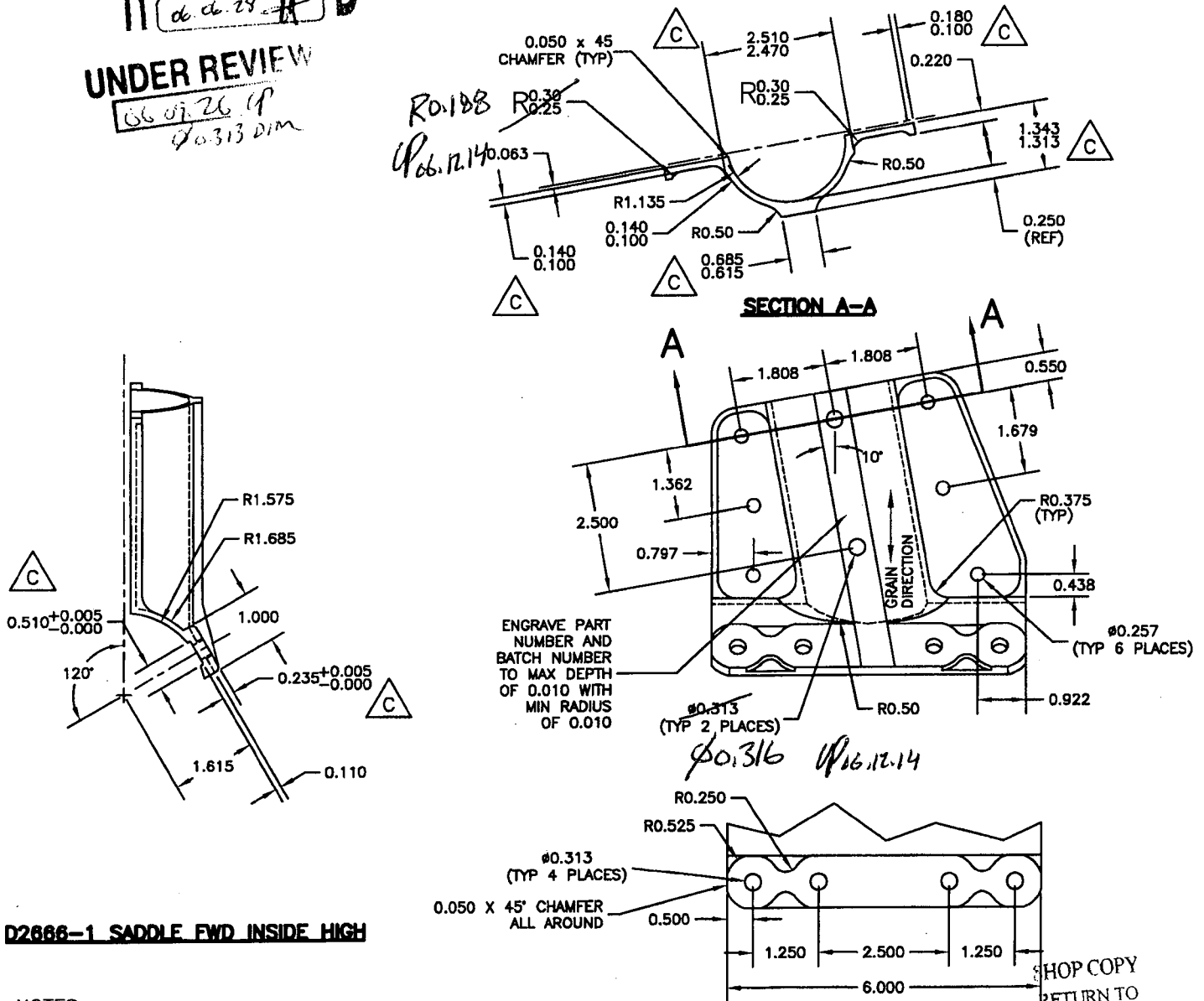
Measured by:	me
Date:	06/12/19

Audited by:	Ed
Date:	06/12/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	


DESIGN		DRAWN BY	CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2666	SHEET 1 OF 1
DATE			TITLE		SCALE
06.05.26			SADDLE FWD INSIDE HIGH		1:3
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.26		INCORPORATE DEO 9122, 9102, 9095		

RELEASED  
06.06.29  
#  
UNDER REVIEW  
06.07.26.1P  
00313 DIM



**D2686-1 SADDLE FWD INSIDE HIGH**

**NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)  
 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1   
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) BREAK ALL SHARP EDGES 0.010 TO 0.020  
 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)  
 6) ALL DIMENSIONS ARE IN INCHES

1.250  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29668

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## Chris Provencal

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 19, 2006 3:31 PM  
**To:** 'S Shahbazian'  
**Cc:** 'Provencal, Chris'; 'Charbonneau, Eric'  
**Subject:** RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.  
See D2661 to D2668 as well as D2932 to D2933.

David

---

**From:** S Shahbazian [mailto:sshahbazian@dartaero.com]  
**Sent:** Thursday, October 19, 2006 1:16 PM  
**To:** Shepherd, David  
**Cc:** Provencal, Chris; Charbonneau, Eric  
**Subject:** Radius dimension on the saddle

Dave,  
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--  
No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

--  
No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006